

Work Order ID 61227

August 11, 2010 11:06:22 AM



Page 1

Item ID:	D2933-2UP	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206 Saddle Right-unpainted					
Start Date:	8/11/10	Start Qty:	6.00	Cust Item ID:		
Required Date:	8/25/10	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>10/8/11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2933	Rev C								

100		HAAS CNC VERTICAL MACHINING #1	0.00	<u>10.9.15</u>	<u>6</u>	<u>1</u>		
HAAS I		Memo	0.00					
HAAS CNC vertical machine #1		Program part number and batch number. <input type="checkbox"/> 1-Inspect part number and batch number are programmed correctly. <input type="checkbox"/> 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet <input type="checkbox"/> 3-Machine Step No 2 of Folio and visually inspect as per						

110		CONVENTIONAL MILLING MACHINE	0.00	<u>10.9.15</u>	<u>6</u>	<u>1</u>		
Mill Conv		Memo	0.00					
Conventional Milling Machine		Machine Keyway and inspect per attached dimension sheet						

120		QC1- Inspect dimensions to dimension sheet	0.00	<u>10.9.15</u>	<u>6</u>	<u>1</u>		
QC		Memo	0.00					
Quality Control								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2933-20P PAR #: _____ Fault Category: machining NCR: Yes No DQA: ✓ Date: 100823
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>61227</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10.9.16</u>	<u>100</u>	<u>2nd operation, used sine keys to align fixture and did not double check. Uneven thickness resulted in 4th operation. AC: operator error L.O.A.</u>	<u>[Signature]</u>	<u>- Remove sine keys + re-align vice. - Scrap + replace work piece.</u>	<u>[Signature]</u> <u>10.9.15</u>	<u>G.A</u> <u>10/09/16</u>	<u>[Signature]</u> <u>100815</u>	<u>[Signature]</u> <u>100815</u>

NOTE: Date & initial all entries

Work Order ID 61227

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Item ID:	D2933-2UP	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206 Saddle Right-unpainted					
Start Date:	8/11/10	Start Qty:	6.00		Cust Item ID:	
Required Date:	8/25/10	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		H.A 10/09/16		6	φ		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		=) JH 10/09/17		6	φ		
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		BR 10-9-17		⑥	φ		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61227

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Page 3

Item ID: D2933-2UP

Accept

Revision ID:

Item Name: 206 Saddle Right-unpainted

Start Date: 8/11/10 Start Qty: 6.00

Required Date: 8/25/10 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 43/

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/2006

10/09/21

MF
10-9-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 61227



Parent Item: D2933-2UP



Parent Item Name: 206 Saddle Right-unpainted


Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001  Saddle Billet		Manufactured	No			100	Each	41.0000	1	6		10.9.15	

Location	Loc Qty	Loc Code
MAT	36	
46409	36	
MAT40	5	
46409	5	

61385 (30)
~~61385 (27)~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	61227
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.124	.124	.124		
B	0.100	0.140		.120	.120	.120	.120		
C	0.100	0.140		.125	.125	.125	.125		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.575	1.575	1.575	1.575		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.117	.117	.117	.117		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.503	.503	.503	.503		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.496	2.496	2.496	2.496		
S	0.240	0.270		.250	.250	.250	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.358	1.358	1.358	1.358		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.133	1.133	1.133	1.133		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	10-8-15

Audited by:	A.A
Date:	10/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	61227
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

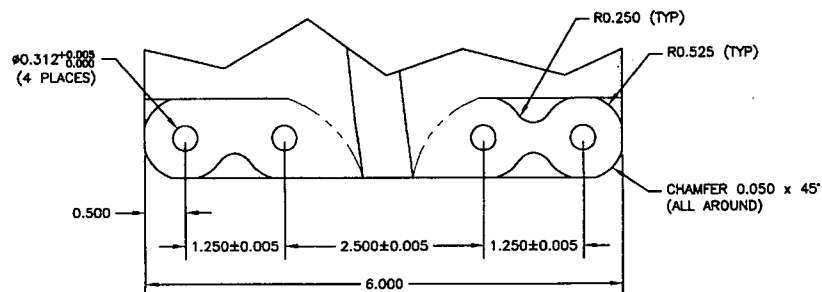
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.124	.124	Vernier	Pa-07		
B	0.100	0.140		.120	.120				
C	0.100	0.140		.125	.125				
D	0.210	0.230		.220	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.500	.510				
I	1.572	1.582		1.575	1.575				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.315	.315				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.117	.117	Micrometer Pa-06			
O	0.540	0.560		.550	.550	Vernier Pa-02			
P	0.490	0.510		.503	.503				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.496	2.496				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.145	.145				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.358	1.358				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.133	1.133	Height gage / 31006			
Y	1.565	1.585	DT8695 A/B	1.575	1.575	"			
Z	0.178	0.198		.188	.188	Red gage			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 10-9-15

Audited by: <i>[Signature]</i>
Date: 10/07/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



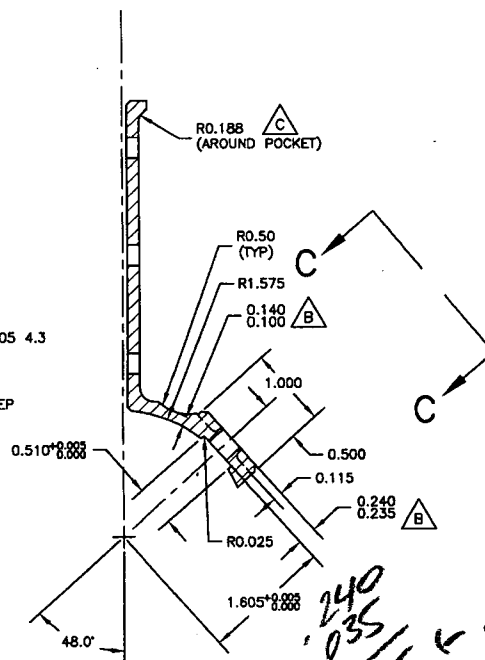
VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

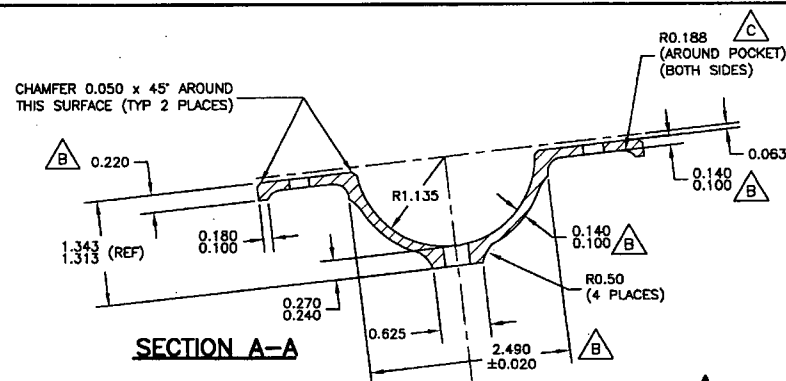
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

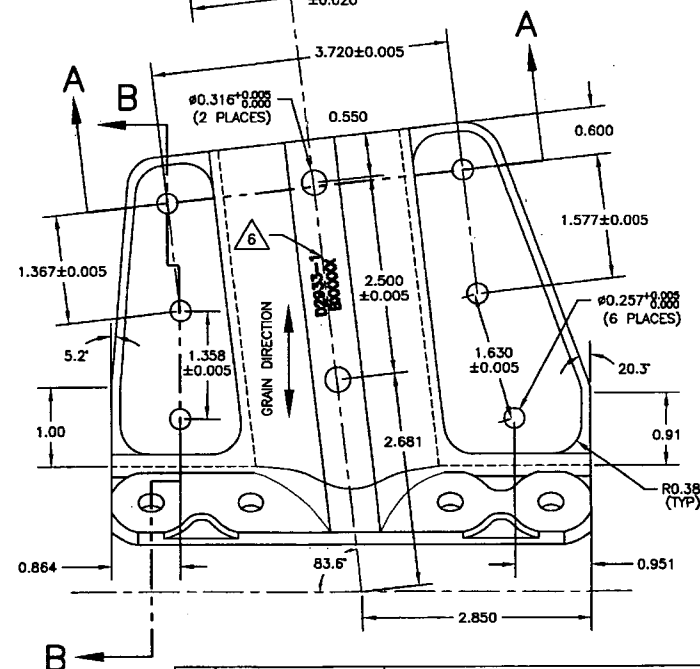
C21018111
W10.61227



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE	TITLE	SADDLE INSIDE
06.11.09		2-3

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DART AEROSPACE USA, INC.

REV. C
SHEET 1 OF 1

SCALE

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